

Work Order ID 69998

Wednesday, May 25, 2011 11:29:02 AM



Page 1

Item ID: D3650-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Seal

Start Date: 5/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-05-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3650

Rev C

100

0.00



Packaging

Packaging

Memo

0.00

Packaging

Cut 8168-1 seal 8.19" long as per dwg D3650

4X ~~0~~ M-L 11/05/26

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SB 11/05/26

(4)

120

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

0.00

Packaging

SB 11/05/26

(4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE	CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69998

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Wednesday, May 25, 2011 11:29:02 AM

Item ID:	D3650-7	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Seal					
Start Date:	5/25/2011	Start Qty: 4.00		Cust Item ID:		
Required Date:	6/3/2011	Req'd Qty: 4.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/5/31

11.05.26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 25, 2011 11:29:10 AM

Page 1

Work Order ID: 69998

Parent Item: D3650-7

Parent Item Name: Seal





Start Date: 5/25/2011

Required Date: 6/3/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-11-19 DD verified by: EC
IPP Rev:B ecn1162 08-04-02 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
81681  SEAL		Purchased	No			100	Each	12.0000	0.7	2.947368			
<div> <div> <div>Location</div> <div>ST412</div> <div>3X</div> <div>1X</div> </div> <div> <div>Loc Qty</div> <div>12</div> <div>116523</div> <div>106312</div> </div> <div> <div>Loc Code</div> <div>12</div> <div></div> <div></div> </div> </div>													
											<div> <div>2.1</div> <div>0.7</div> </div>	<div> <div>m-l</div> <div>11/05/26</div> </div>	<div> <div>*</div> </div>

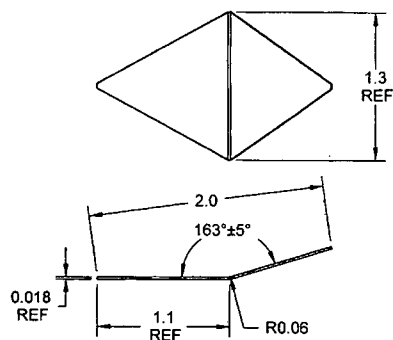
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

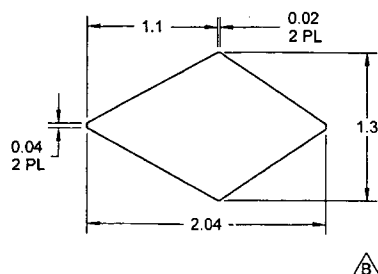
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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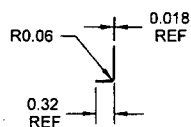
NOTE: Date & initial all entries



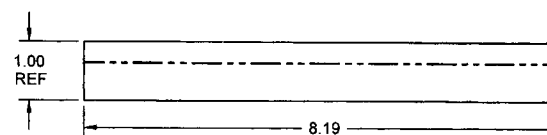
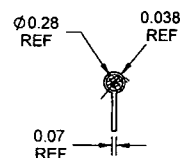
D3650-11 FILLER PLATE
(MAKE FROM D3650-11F FLAT PATTERN)



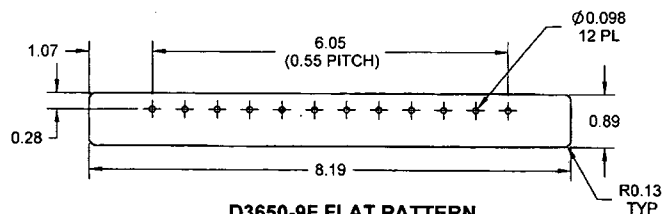
D3650-11F FLAT PATTERN



D3650-9 ANGLE
(MAKE FROM D3650-9F FLAT PATTERN)



D3650-7-8.19 SEAL



D3650-9F FLAT PATTERN

D3650-9 & D3650-11 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI.018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) D3650-9 WEIGHT: 0.05 lb
- 8) D3650-11 WEIGHT: 0.007 lb

D3650-7-8.19 NOTES:

- 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1) POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI.018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lb
- 8) PART NUMBER: D3650-7-X.XX
WHERE X.XX = LENGTH IN INCHES
EG. 12.50" LONG = D3650-7-12.50

DEO ATTACHED

RELEASED
08/10/14

UNDER REVIEW
08/07/14
OK

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3650	REV. C
MFG. APPR.			SHEET 9 OF 9
APPROVED		TITLE TOP PANEL ASSEMBLY	SCALE NTS
DE APPR.		COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	08.10.14		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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